

Date: Thursday, 3/30/2006 8:30:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET		
Job Number	: 26408		Part Number	: D28572		
Estimate Number	: 10347		Drawing Number	: D2857 REV A1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/30/2006	S.O. No. : N/A	Drawing Revision	: A1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/6/2006		
Previous Run	: 26209		Qty:	40	Um:	Each
Written By	: <u>See COMMENT Below</u>					
Checked & Approved By	: <u>SA 06.03.30</u>					
Comment	: Est C 06.06.22 Removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
Comment: Qty.: 0.4594 f(s)/Unit Total : 18.3750 f(s) Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B200001250) Batch <u>M100451</u>		
<u>SA 06.03.30 40</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 5.2"		
<u>SA 06.03.30 40</u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2857-4 <u>JL 06.03.30 D2857-2</u>		
<u>JL / SA 06.03.30 40</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
<u>JL / SA 06.03.30 40</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 26408

Part Number: D28572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

J.L 06-04-01 40

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SAD 06-04-01 40

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

DL 06-04-01 40

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06-04-01 40

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST165

10 06-04-01 40

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-04-01 40

Job Completion



U 06-04-01 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26408
Description: Hinge Bracket	Part Number:	D2857-2
Inspection Dwg: D2857 Rev: A1		Page 1 of 1

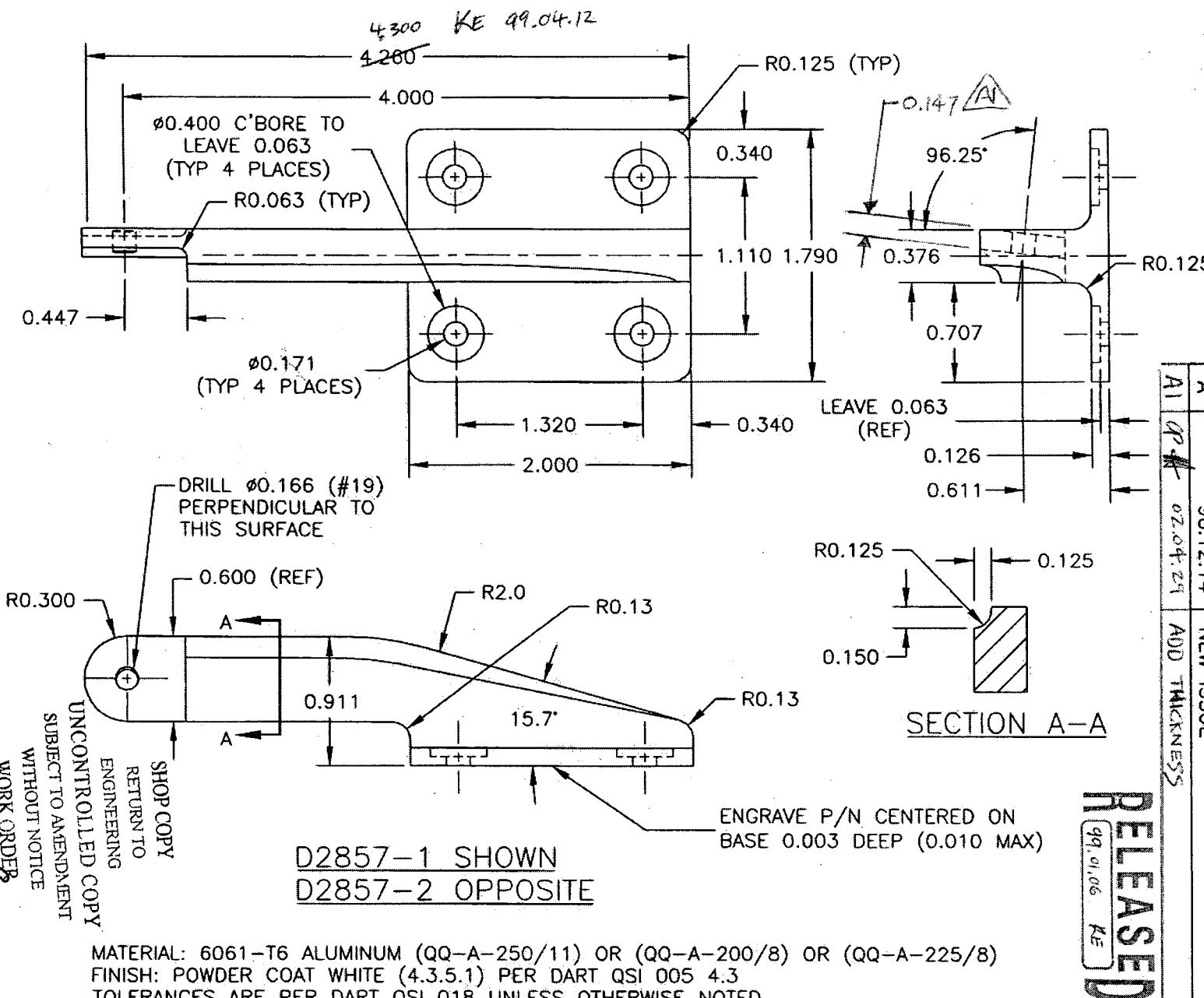
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010					
0.340	+/-0.010					
1.110	+/-0.005					
1.790	+/-0.010					
1.320	+/-0.005					
2.000	+/-0.010					
Ø0.171	+0.005/-0.000					
0.147	+/-0.010					
0.376	+/-0.010					
0.126	+/-0.010					
0.611	+/-0.010					
0.063	+/-0.010					
Ø0.166	+0.005/-0.000					
0.911	+/-0.010					
0.600	+/-0.010					
0.125	+/-0.010					
0.150	+/-0.010					

Measured by:	SD	Audited by:	gmk	Prototype Approval:	N/A
Date:	06-03-30	Date:	06/04/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	SD



DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	JP	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	DRAWING NO.
98.12.14	JP	D2857
		TITLE
A	98.12.14	HINGE BRACKET
		ADD THICKNESS
RELEASED		99.01.06 KE
		REV. A
		SHEET 1 OF 1
		SCALE
		1:1